



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5404-042
Job Sheet 204611



Part No: D5404-042

Job Qty: 4 pcs

Part Name: RH Heavy-Duty Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/16/19

Job Tracking No:

Due Date: 12/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5404 REV.C SHEET 2 IPP REV:A 16.03.23 NEW ISSUE DD VERF:JLM IPP REV:B 17.01.05 AS PER
DWG REV.A DD VERF:JLM IPP REV:C 19.05.16 AS PER DWG REV.B DD VERF:JFS/IPP Rev.C 19.11.21
drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	12/20/19	12/20/19	0.00	3.20	Large Fab - 1		ms
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	4 pcs	12/20/19	12/20/19	0.00	0.00	QC 9 - 10		EL
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	12/20/19	12/20/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL.: 1 613 632-5200
Email: sales@dartae.com
www.dartaerospace.com

Container No: S242610



Part No: D5404-042

Job No: 204611

Material No/Batch: S242610

Revision: C

Inspector:

Date:

Plex 12/16/19 7:04 AM Dart.lajeunesse.marie

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	DAS
150	Spray Paint - 2 - B4B	4 pcs	12/20/19	0.00 0.67	Spray Paint - 1 - B4B	41 DEC 20 2019
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 5	4 pcs	12/20/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DEC 23 2019
					QC 5 - 9	DAS 68
					QC 5 - 50	9-89
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					170	Packaging 3-1 - Stock - B4B
Packaging 3 - 2 - B4B						
Packaging 3 - 3 - B4B						
Packaging 3 - 4 - B4B						
Packaging 3 - 5 - B4B						
Packaging 3 - 6 - B4B						
Packaging 3 - 7 - B4B						
Packaging 3 - 8 - B4B						
Packaging 3 - 9 - B4B						
Packaging 3 - 10 - B4B						
Packaging 3 - 11 - B4B						
Packaging 3 - 12 - B4B						
Packaging 3 - 13 - B4B						
Packaging 3 - 14 - B4B						
Packaging 3 - 15 - B4B						
Packaging 3 - 16 - B4B						
Packaging 3 - 17 - B4B						
Packaging 3 - 18 - B4B						
Packaging 3 - 19 - B4B						
Packaging 3 - 20 - B4B						
Packaging 3 - 21 - B4B						
Packaging 3 - 22 - B4B						
Packaging 3 - 23 - B4B						
Packaging 3 - 24 - B4B						
Packaging 3 - 25 - B4B						
Packaging 3 - 26 - B4B						
Packaging 3 - 27 - B4B						
Packaging 3 - 28 - B4B						
Packaging 3 - 29 - B4B						

Plex 12/16/19 7:04 AM Dart.lajeunesse.marie

Plex 12/16/19 7:04 AM Dart.lajeunesse.marie

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	12/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAE
				QC 21 - SA - 53	21

Part Op 100 - 1- Weld D4155-041 to wearplate as per dwg D5404 304 S.S. Welding Rod BATCH #: 74436586
 Descriptions: Transfer drill holes in bar 3- Use DT9684 to check fit after welding 4- Cut extra material on back end of wearplate if necessary 5- ENSURE WELDED CLAMP FITS AROUND A 3.23" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 150 - BATCH: M139618 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING. 0.020 - 0.040 THICK. PER DART QSI 005 4.9. S 235921
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4155-041	Wearbar Assembly	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5197209
D5404-2	Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5030836
D5617-3	Clamp	12 pcs (3 ea)	100-Large Fab - Welded Assy-1	5038312
D5678-1	Hex Nut	12 pcs (3 ea)	100-Large Fab - Welded Assy-1	3832853

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D4155-041	4	6	0
	D5404-2	4	4	0
	D5617-3	12	30	0
	D5678-1	12	45	0

Part Specifications

Specifications could not be found.

Plex 12/16/19 7:04 AM Dart.lajeunesse.marie

